

Work Order ID 144749

144749

Page 2

Item ID: D3571-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Guide

Stop *NS2*

Start Date: 5/10/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130						10	0		
QC	Memo	0.20							16/05/02
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10	0		16/05/02
HandFinish	Memo	0.60							
Hand Finishing									

150	Powder Coat	0.00							DAS 13 9-89
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3					10			
Powdercoat	Memo	0.60							
Powder Coating									

Outsource

ISS
padding

Review & Inspect

10x 8/16-05-12

Work Order ID 144749

Friday, April 29, 2016 11:18:08 AM

144749

Page 3

Item ID: D3571-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Guide
Start Date: 5/10/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/24/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				(10)			DAS 38 9-89 MAY 12 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stor 3</u> Memo	0.00 0.10				10			MAY 12 2016 DAS 6 9-89
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00				MCS			MAY 12 2016 MCS MAY 12 2016

Picklist Print

Friday, April 29, 2016 11:18:07 AM

Page 1

Work Order ID: 144749

144749

Parent Item: D3571-3

D3571-3

Parent Item Name: Guide

Start Date: 5/10/2016

Required Date: 5/24/2016

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-02-01 JLM

IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			110	f	22.4405	0.241	2.536842			

M6061T6B0 750X01 500

2.583'

DAS
20
9-89

16-04-29

M6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT

22.4405

134284

7.4

m131700

2.7905

m132876

0.25

m134377

12

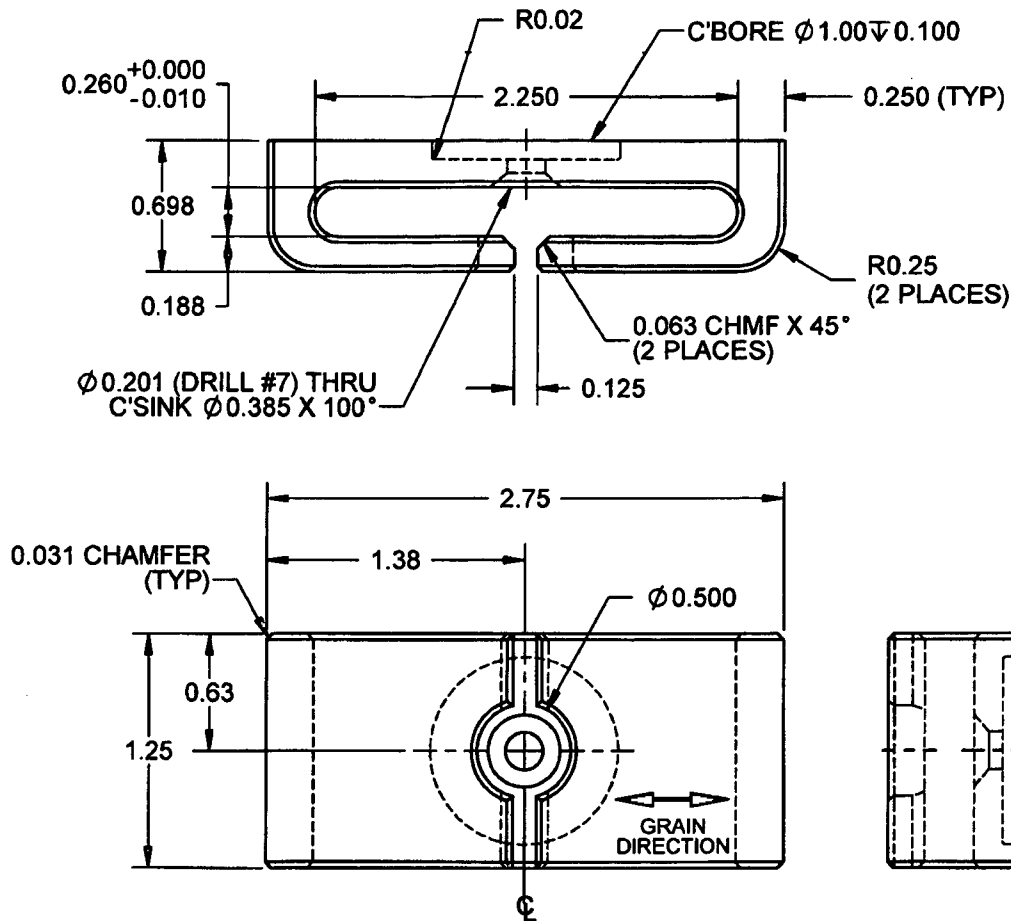
2.583'



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED

07.01.12



D3571-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT CL

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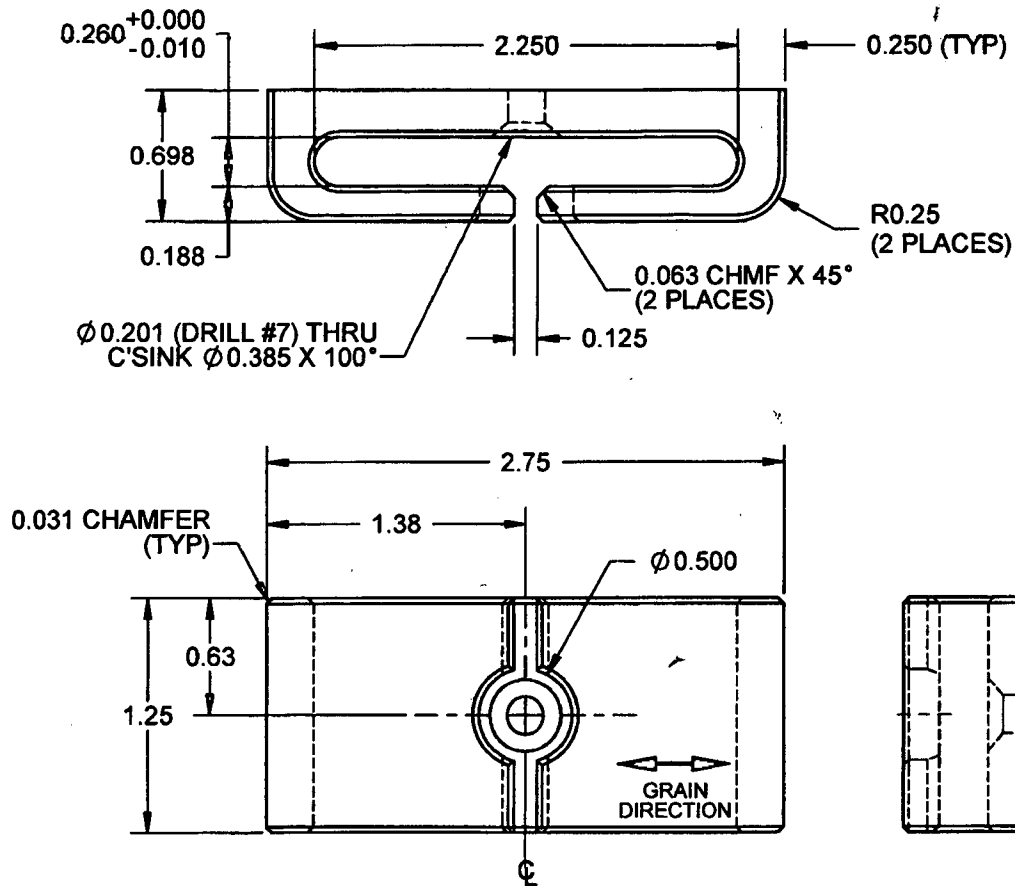
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3571	REV. A
DATE 07.01.29		TITLE GUIDE	SHEET 2 OF 2 SCALE 1:1

RELEASED

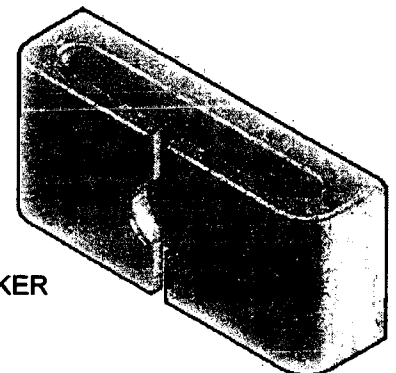
07.01.12



(**D3571-3 GUIDE**)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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DART AEROSPACE LTD		Work Order:	144749
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.698	✓		SL10	Vern
2.75	+/-0.030	2.750	✓			
1.38	+/-0.030	1.374	✓			
1.25	+/-0.030	1.247	✓			
0.63	+/-0.010	.6235	✓			
0.031 chamfer	+/-0.010	.032	✓			
Ø0.500	+0.006/-0.001	.502	✓			
Ø0.201	+0.005/-0.001	.202	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
0.260	+0.000/-0.010	.259	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.382 x 100°	✓			
0.125	+/-0.010	.127	✓			
2.250	+/-0.010	2.245	✓			
0.250	+/-0.010	.253	✓			
0.188	+/-0.010	.186	✓			
0.063 chamfer	+/-0.010	.063	✓			

Measured by: DAS 23	Audited by: DAS 14	Prototype Approval:	N/A
Date: 16-04-29	Date: 16/05/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32331**

Purchase Order Date 5/10/2016

PO Print Date 5/11/2016

Page Number 2 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total:

\$108.00

4 144747 D3542-1 BRACKET 5/12/2016 8.00
Yes
5/12/2016

\$9.00

\$72.00

Powder coat per QSI005

Line Total:

\$72.00

5 144749 D3571-3 GUIDE 5/12/2016 10.00
Yes
5/12/2016

\$5.00

\$50.00

Powder coat per QSI005

Line Total:

\$50.00

6 143417 D5162-041 SEAT 5/12/2016 1.00
STRUCTURE Yes
5/12/2016

\$20.00

\$20.00

Powder coat per QSI005

Line Total:

\$20.00

PO Instructions: PROCUREMENT QUALITY CLAUSES
A000 CLAUSES NOT REQUIRED

Note:

5/11/2016

Generic Quote Calculator - quoted by: Roger L

Line	Part Number	Qty	Requirement 1	Unit Cost	Req 2	Unit Cost	Req 3
1	142768	14	powder coated	\$5.25		\$0.00	
2	142663	14	powder coated	\$9.00		\$0.00	
3	144623	12	powder coated	\$9.00		\$0.00	
4	144747	8	powder coated	\$9.00		\$0.00	
5	144749	10	powder coated	\$5.00		\$0.00	
6	143417	1	powder coated	\$20.00		\$0.00	
7	144917	2	powder coated	\$14.00		\$0.00	
8	144831	6	powder coated	\$18.00		\$0.00	
9	144949	1	powder coated	\$20.00		\$0.00	
10	Adminastration fee			\$125.00		\$0.00	
11						\$0.00	
12						\$0.00	
13						\$0.00	
14						\$0.00	
15				\$0.00		\$0.00	
16				\$0.00		\$0.00	
17				\$0.00		\$0.00	
18				\$0.00		\$0.00	
Repeat Job		☒ YES	☐ NO	Black Ano \$125	Color Ano \$150.00	Passivate	
Lot Charges		Paint \$185	Clear Ano \$125	Hard Ano \$175	Chem Film		
COMMENT PO32331							
Pricing is based on lot charges when possible							
Anodize Pricing is based on how many parts can be processed per hour - when exceeding lot ch							
Painting Pricing is based on how many parts can be processed per hour - when exceeding lot ch							

8/6-05-12.

Unit Cost	TOTAL COST
\$0.00	\$73.50
\$0.00	\$126.00
\$0.00	\$108.00
\$0.00	\$72.00
\$0.00	\$50.00
\$0.00	\$20.00
\$0.00	\$28.00
\$0.00	\$108.00
\$0.00	\$20.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
\$0.00	\$0.00
	\$605.50
\$115.00	
\$115.00	
arges	
arges	